

Work Order ID 126834

126834

Page 1

Wednesday, November 26, 2014 4:18:08 PM

Item ID: D139-799-025

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Cargo Compartment Rain Gutter

Start Date: 11/26/2014 Start Qty: 6.00

6
6

Cust Item ID:

Required Date: 12/12/2014 Req'd Qty: 6.00

Customer:

Reference:

Approvals: Process Plan: mf Date: 11-11-26 Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***
Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
IIN-D139-799	I

100	Document Control	0.00							
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100

DC

Doc.Control -USB or Paperwork

Memo M.R.
Photocopy bluefile & type labels per PPP D139-799-025
CHG001

(6x)

DAS
46
9-89

JAN 21 2015

MCS 15-01-21

110	Pick Kit	0.00							
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110

Packaging

Packaging

Memo

0.00

(6x)

DAS
28
9-89

JAN 20 2015



120	QC4- 100% Inspect kits for completeness	0.00							
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120

QC

Quality Control

Memo

0.00

(6x)

DAS
46
9-89

JAN 20 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Large Fab ☐	Composite ☐	Supplier ☐																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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126834

Page 2

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Item ID: D139-799-025

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Cargo Compartment Rain Gutter

Start Date: 11/26/2014 Start Qty: 6.00

6

Cust Item ID:

Required Date: 12/12/2014 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130

0.00

130

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D139-799-025

Location: 019

PPP rev: _____

6x

DAS
46
9-89

JAN 20 2015

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

MLJ 1501-21

ME
15-1-21

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
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Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

Page 1

Wednesday, November 26, 2014 4:18:08 PM

Work Order ID: 126834

126834

Parent Item: D139-799-025

D139-799-025

Parent Item Name: Cargo Compartment Rain Gutter

Start Date: 11/26/2014

Required Date: 12/12/2014

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP REV:A 12.01.19 NEW ISSUE DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D4456-1

Manufactured

No

110

Each

9.0000

1 1/6

**

DAS

JAN 20 2015

28

9-89

D4456-1

Fwd Raingutter, LH

DAS
46
9-89

Location

Loc Qty

Loc Code

ST108

9

114083

9

D4456-2

Manufactured

No

110

Each

7.0000

1 1/6

**

DAS

28

9-89

D4456-2

Fwd Raingutter, RH

DAS
46
9-89

Location

Loc Qty

Loc Code

ST108

7

114084

7

D4456-3

Manufactured

No

110

Each

8.0000

1 1/6

**

DAS

28

9-89

D4456-3

Aft Raingutter, LH

DAS
46
9-89

Location

Loc Qty

Loc Code

ST108

8

114085

7

99695

1

D4456-4

Manufactured

No

110

Each

13.0000

1 1/6

**

DAS

28

9-89

D4456-4

Aft Raingutter, RH

DAS
46
9-89

Location

Loc Qty

Loc Code

ST108

13

107640

1

114086

12

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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Handling/Pre									
Material									
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Offset/Setup									
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Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

Page 2

Wednesday, November 26, 2014 4:18:08 PM

Work Order ID: 126834

126834

Parent Item: D139-799-025

D139-799-025

Parent Item Name: Cargo Compartment Rain Gutter

Start Date: 11/26/2014

Required Date: 12/12/2014

Start Qty: 6.00

Required Qty: 6.00

D4456-5

Manufactured No

110

Each

16.0000

2 1/8

**

DAS
28
9-89

JAN 20 2015

D4456-5

Center Raingutter

DAS
46
9-89

Location

ST259

Loc Qty

16

Loc Code

16

114087

12



DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

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REFERENCE ONLY

JAN 20 2015

DART AEROSPACE USA, INC.

DAS
46
9-89

IIN-D139-799
Page 53 of 53

Qty -021	Qty -025	Qty -031	Part Number	Description
X			D139-799-021	CARGO COMPARTMENT PROTECTIVE TRIM KIT
	X		D139-799-025	CARGO COMPARTMENT RAINGUTTER KIT
		X	D139-799-031	CARGO COMPARTMENT PROTECTIVE TRIM KIT
2			D4427-1	SCUFF PLATE
	1		D4456-1	FWD RAINGUTTER, LH
	1		D4456-2	FWD RAINGUTTER, RH
	1		D4456-3	AFT RAINGUTTER, LH
	1		D4456-4	AFT RAINGUTTER, RH
	2		D4456-5	CENTER RAINGUTTER
		2	D4735-1	SCUFF PLATE
10		10	MS21075L3	NUTPLATE
10		10	MS27039-1-09	SCREW
10		10	NAS1149C0332R	WASHER (or AN960C10L)

Qty -023	Part Number	Description
X	D139-799-023	ANTI-ROTATION BLOCK KIT
5	D4310-1	BLOCK, ANTI-ROTATION
10	MS24665-155	PIN, COTTER

Qty -029	Part Number	Description
X	D139-799-029	HINGED FUEL CAP KIT
1	D5043-041	FUEL CAP HINGE ASSEMBLY
2	AN525-416R10	SCREW
1	CB 200	3.5g ACRYLIC ADHESIVE

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Revision: I
Date: 14.03.06